

The Haven KleenCut™ Model 600 Series utilizes the supported shear cutting process, designed for heavy wall and short length applications. The cutoff can be used with a tube loader for straight tube stock or it can cut tubing from coils. The tube is advanced from the loader or coil into the cutoff hitch-feed, or servo feed assembly that determines the part cut length. The tooling design uses two outer rings and one inner punch assembly. The punch is a two piece “floating” design. The stationary side of the punch, or load side, is assembled with a suppressor cage that assures the punch is positioned at the cut line. The forward feeding action of the tube applies adequate frictional force to accomplish this. The movable side of the punch is held in place by a “snubber” rod. The rod acts both as a support member for the punch assembly and as a stripping rod for the cut parts. As the part is sheared, it is deposited over the rod. When the rod is full, it will automatically retract and strip the parts. The rod then returns to the cut position to accept new parts.

The Haven KleenCut™ Model 700 Series utilizes the supported shear cutting process to cut tubing to precise lengths automatically. The cut head is mounted on a machine base and is integrated with the tube loader, the tube mandrel feed and the length target assembly. After the tube has been loaded onto the cutting mandrel, the cycle reverses itself and feeds the tube back through the die towards the target. When the tube contacts the target, the cut cycle begins. Two high-pressure cylinders activate almost simultaneously, first in a vertical motion, followed by a horizontal motion. The timing and stroke of the cutting cycle is adjustable and controlled from the operator panel.

Specifications

	Model 620	Model 640	Model 725	Model 740
Cutting Capacity:	.500" – 2.00" (137mm – 50.8mm)	.500" – 4.00" (13mm – 102mm)	.500" – 2.50" (13mm – 63.5mm)	1.00" – 4.00" (25mm – 102mm)
Max. Wall Thickness:	20% of Diameter	20% of Diameter	8% of Diameter	8% of Diameter
Cycle Rate	4,800 cycle/hour	3,600 cycle/hour	5,700 cycle/hour	5,700 cycle/hour
Cut Lengths	up to 10.0" (254mm)	up to 14.0" (305mm)	up to 24.0" (610mm)	up to 24.0" (610mm)
Cut Length Tolerance	± .010" (.25mm)	± .010" (.25mm)	± .010" (.25mm)	± .010" (.25mm)

Note: All figures subject to change per specific application.

Integrated Options:

- Automatic Bundle Loader-Unscramble
- Servo length control
- Coiled tube feeding with tube straightening (Models #620 & #640 only)
- Automated transfer systems to secondary processes
- Secondary processes
 - Wire Brush Deburring - [click for more info](#)
 - Double End Chamfering and Facing - [click for more info](#)
 - Measuring and Inspection Systems - [click for more info](#)
 - Tube Packaging Systems - [click for more info](#)

Call us today 912.265.7536

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The Complete Solution To The Tube Cutting and End Finishing Industry

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